

Date: Monday, 12/19/2005 11:13:28 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BRACKET ASSEMBLY
Job Number :	25285		
Estimate Number :	11519		
P.O. Number :	N/A	Part Number :	D3152042
This Issue :	12/19/2005	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3152 REV B
First Issue :	N/A	Project Number :	N/A
Previous Run :	N/A	Drawing Revision :	B
	Type :	Material :	N/A
	SMALL /MED FAB	Due Date :	12/23/2005
Written By :	<u>See comment below</u>		Qty: <u>12</u> <u>10</u> <u>Um:</u> Each
Checked & Approved By :	<u>See comment below</u>		
Comment :	Est Rev:B Removed Purchasing 05-12-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31524	Seal
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12 10.0000 Each(s)

Pick:

Qty	Part #	Description	Batch:
1	D3152-4	Seal	(7) m13159 (5) m10536-17

m10512/19

2.0	D31522	Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part #	Description	Batch:
1	D3152-2	Bracket	(12) B18867

m10512/19

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond D3152-3 Seal to D3152-1 Bracket using RTV 732 per Dwg D3152. RTV 732 Black

Batch: m16368

Expiry: 17 Feb 2007

Identify as D3152-041

m10512/19

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Job 01-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/01/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/19/2005 11:13:28 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 25285

Part Number: D3152042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

monitors

6/1/17

(12)

6.0

DC

DOCUMENT CONTROL



(12)

Comment: DOCUMENT CONTROL

SUE 06/01/18

(12)

SP 06/01/18

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3152	REV. B SHEET 1 OF 2
DATE 04.10.18		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	02.04.24	NEW ISSUE	
B	04.10.18	ADD PART MARKING & RTV 732 BLACK	

RELEASED
04.11.23

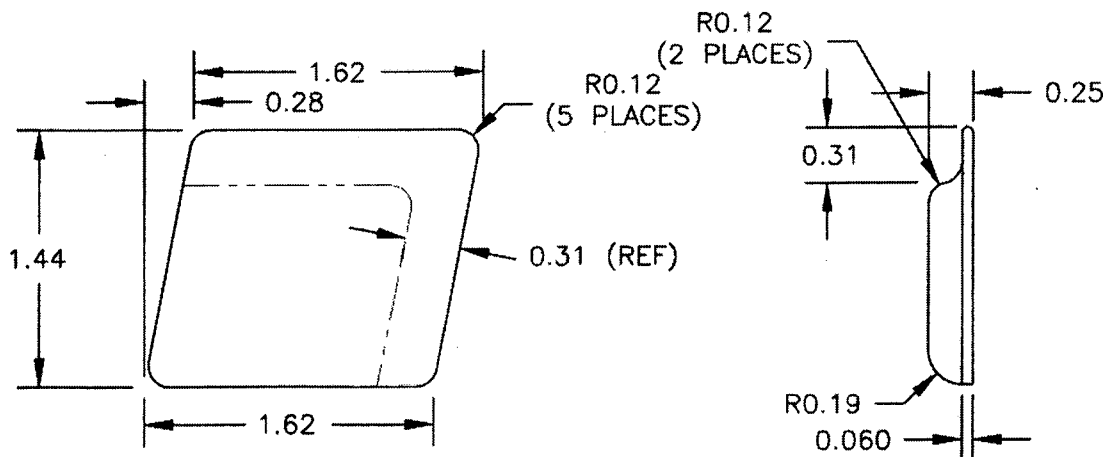
D3152-041 BRACKET ASSEMBLY
D3152-042 BRACKET ASSEMBLY

IDENTIFY WITH DART P/N
USING FINE POINT PERMANENT
INK MARKER

D3152-3 (-041)
or D3152-4 (-042)

D3152-1 (-041)
or D3152-2 (-042)

BOND D3152-3/-4(OPP) SEAL TO
D3152-1/-2(OPP) BRKT USING
RTV 732 CLEAR (A/R)
OR RTV 732 BLACK (A/R)



D3152-3 SEAL (SHOWN)
D3152-4 SEAL (OPPOSITE)

1. D3152-3 REPLACES PREMIER P/N B30-23000-243
D3152-4 REPLACES PREMIER P/N B30-23000-244
2. MAKE D3152-3 PER TOOL # B30-23000-243T
MAKE D3152-4 PER TOOL # B30-23000-244T
3. MATERIAL: RTV 732 BLACK
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5. ALL DIMENSIONS ARE IN INCHES

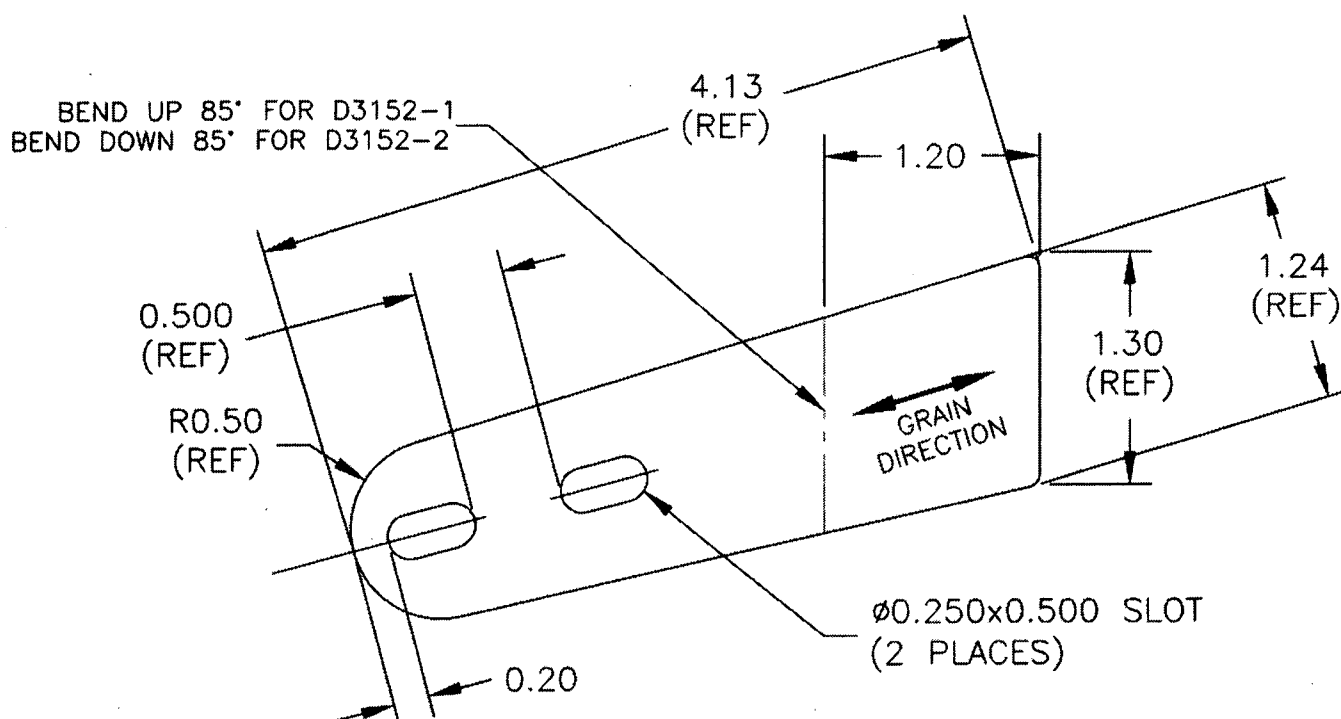
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DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3152	REV. B SHEET 2 OF 2
DATE 04.10.18		TITLE BRACKET ASSEMBLY	SCALE 1:1

RELEASED
04.11.23



D3152-1/-2 BRACKET

1. D3152-1 REPLACES PREMIER P/N B30-23000-223
D3152-2 REPLACES PREMIER P/N B30-23000-224
2. MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF DART SPEC. M2024T3S.063)
3. FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5. ALL DIMENSIONS ARE IN INCHES
6. BREAK ALL SHARP EDGES 0.005 TO 0.010
7. MACHINE PER DWG FILE "D3152-B2.DWG"

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